

Date: Thursday, 7/20/2006 1:05:49 PM  
 User: Linda Lacelle

## Process Sheet

|   |   |
|---|---|
| Customer : CU-DAR001 Dart Helicopters Services      | Drawing Name : SADDLE FITTING, AFT (OUTBOARD/INBOARD) |
| Job Number : 27994                                  |   |
| Estimate Number : 10533                             |   |
| P.O. Number : NIA                                   | Part Number : D2573                                   |
| This Issue : 7/20/2006 S.O. No. : NIA               | Drawing Number : D2573 REV E                          |
| Prsht Rev. : NC                                     | Project Number : N/A                                  |
| First Issue : 7/20/2006 Type : MACHINED PARTS       | Drawing Revision : E                                  |
| Previous Run : 27889                                | Material : NIA  |
| Written By : <u>[Signature]</u>                     | Due Date : 8/5/2006 Qty: 16 Um: Each                  |
| Checked & Approved By : <u>[Signature]</u> 06.07.21 |   |
| Comment : Est: 1 As Per RevE 06-01-27 JLM           |   |

## Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

|     |          |                          |
|-----|----------|--------------------------|
| 1.0 | D6101007 | 7075-T7351 8.25X7.75X2.5 |
|-----|----------|--------------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total: 16.0000 Each(s)  
 7075-T7351 8.25X7.75X2.5  
 Make from D6101-007 billet for D2573  
 Ensure that grain is along 7.75" length  
 Batch No: B25354

|     |       |                                |
|-----|-------|--------------------------------|
| 2.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|--------------------------------|



Comment: HAAS CNC VERTICAL MACHINING #1  
 Program Batch No. 27994 Double check by: SD

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets  
 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets  
 4-Deburr and remove all machining marks  
 5-Tumble to remove sharp edges.

|     |               |                              |
|-----|---------------|------------------------------|
| 3.0 | MILLING CONV. | CONVENTIONAL MILLING MACHINE |
|-----|---------------|------------------------------|



Comment: CONVENTIONAL MILLING MACHINE  
 Machine keyway as per dwg D2573 & D2574

|     |     |  |
|-----|-----|--|
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                 |                          |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Mfg / Design<br>Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                 |                          |
|      |      |                    |    |      |     |                                 |                          |

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                  |                |                           |                        |                          |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                  |                | Verification<br>Section C | Approval<br>Design Mgr | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Design Mgr       | Action Description<br>Design Mgr | Sign &<br>Date |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 06/10/03

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Thursday, 7/20/2006 1:05:49 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 27994

Part Number: D2573

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

MS 06/09/22 16

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SAB 08/09/24 16

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

06/10/02 x 16

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

06/10/02 (16)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 51351

06/10/02 (16)

10.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/10/03

Job Completion



06-10-03

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                 |                          |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Mfg / Design<br>Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                 |                          |
|      |      |                    |    |      |     |                                 |                          |

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                  |                |                           |                        |                          |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                  |                | Verification<br>Section C | Approval<br>Design Mgr | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Design Mgr       | Action Description<br>Design Mgr | Sign &<br>Date |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

|  |                           |
|--|---------------------------|
| <b>DART AEROSPACE LTD</b>                | <b>Work Order:</b> 27994  |
| <b>Description:</b> Saddle, Aft Outboard | <b>Part Number:</b> D2573 |
| <b>Inspection Dwg:</b> D2573 Rev. E      | <b>Page 1 of 1</b>        |

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

| Dim           | Min   | Max   | Go/No Go Gauge | Recorded Actual Dimensions |       |       |       | By | Date |
|---------------|-------|-------|----------------|----------------------------|-------|-------|-------|----|------|
|               |       |       |                | 1                          | 2     | 3     | 4     |    |      |
| A             | 0.438 | 0.443 | DT8682         | ✓                          | ✓     | ✓     | ✓     |    |      |
| B             | 1.745 | 1.755 |                | 1.747                      | 1.746 | 1.748 | 1.750 |    |      |
| C             | 3.495 | 3.505 |                | 3.496                      | 3.496 | 3.500 | 3.500 |    |      |
| D             | 1.745 | 1.755 |                | 1.747                      | 1.746 | 1.748 | 1.750 |    |      |
| E             | 7.990 | 8.010 |                | 8.001                      | 8.005 | 8.006 | 8.004 |    |      |
| F             | 0.490 | 0.510 |                | 0.500                      | 0.500 | 0.497 | 0.501 |    |      |
| G             | 0.257 | 0.262 | DT8683         | ✓                          | ✓     | ✓     | ✓     |    |      |
| H             | 0.375 | 0.380 | DT8684         | ✓                          | ✓     | ✓     | ✓     |    |      |
| I             | 0.490 | 0.510 |                | 0.510                      | 0.501 | 0.500 | 0.503 |    |      |
| J             | 1.174 | 1.184 |                | 1.177                      | 1.176 | 1.177 | 1.179 |    |      |
| K             | 0.558 | 0.578 |                | 0.569                      | 0.569 | 0.564 | 0.570 |    |      |
| L             | 1.174 | 1.184 |                | 1.177                      | 1.176 | 1.177 | 1.179 |    |      |
| M             | 1.365 | 1.375 |                | 1.368                      | 1.365 | 1.370 | 1.372 |    |      |
| N             | 2.495 | 2.505 |                | 2.500                      | 2.497 | 2.495 | 2.497 |    |      |
| O             | 4.119 | 4.129 |                | 4.119                      | 4.126 | 4.120 | 4.124 |    |      |
| P             | 0.115 | 0.135 |                | 0.119                      | 0.123 | 0.125 | 0.125 |    |      |
| Q             | 0.115 | 0.135 |                | 0.135                      | 0.135 | 0.135 | 0.135 |    |      |
| R             | 0.240 | 0.260 |                | 0.241                      | 0.242 | 0.243 | 0.244 |    |      |
| S             | 0.115 | 0.135 |                | 0.124                      | 0.120 | 0.123 | 0.120 |    |      |
| T             | 0.178 | 0.198 |                | 0.188                      | 0.188 | 0.188 | 0.188 |    |      |
| U             | 3.210 | 3.250 |                | 3.228                      | 3.230 | 3.230 | 3.230 |    |      |
| V             | 0.230 | 0.250 |                | 0.239                      | 0.230 | 0.230 | 0.234 |    |      |
| W             | 0.115 | 0.135 |                | 0.115                      | 0.117 | 0.121 | 0.120 |    |      |
| X             | 0.308 | 0.313 |                | 0.310                      | 0.311 | 0.310 | 0.310 |    |      |
| Y             | 0.760 | 0.765 |                | 0.760                      | 0.760 | 0.766 | 0.760 |    |      |
| Z             | 0.352 | 0.372 |                | 0.369                      | 0.368 | 0.369 | 0.367 |    |      |
| AA            | 0.470 | 0.530 |                | 0.500                      | 0.500 | 0.500 | 0.500 |    |      |
| AB            | 0.615 | 0.635 |                | 0.632                      | 0.635 | 0.630 | 0.629 |    |      |
| AC            | 0.053 | 0.073 |                | 0.063                      | 0.063 | 0.063 | 0.063 |    |      |
| AD            | 0.240 | 0.260 |                | 0.240                      | 0.240 | 0.240 | 0.240 |    |      |
| AE            | 1.500 | 1.520 |                | 1.502                      | 1.512 | 1.512 | 1.514 |    |      |
| AF            | 0.115 | 0.135 |                | 0.135                      | 0.135 | 0.135 | 0.135 |    |      |
| AG            | 0.240 | 0.280 |                | 0.260                      | 0.260 | 0.260 | 0.260 |    |      |
| AH            | 0.240 | 0.260 |                | 0.250                      | 0.248 | 0.240 | 0.244 |    |      |
| AI            | 2.000 | 2.020 |                | 2.002                      | 2.003 | 2.002 | 2.003 |    |      |
| AJ            | 0.023 | 0.043 |                | 0.033                      | 0.033 | 0.033 | 0.033 |    |      |
| Accept/Reject |       |       |                |                            |       |       |       |    |      |

|                                 |                |
|---------------------------------|----------------|
| Measured by: J.G. / [Signature] | Audited by: MS |
| Date: 06/09/06 / 06/09/12       | Date: 06/09/22 |

| Rev | Date     | Change                                  | Revised by         | Approved    |
|-----|----------|---|--------------------|-------------|
| A   |          | New Issue                               | RF                 |             |
| B   | 02.09.26 | Re-format; Added Rev. D                 | KJ                 |             |
| C   | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ                 |             |
| D   | 05.05.05 | Added dimension AI                      | KJ/RF              |             |
| E   | 05.12.05 | Added dimension AJ                      | KJ/JLM [Signature] | [Signature] |

|  |                           |
|--|---------------------------|
| <b>DART AEROSPACE LTD</b>                | <b>Work Order:</b> 27994  |
| <b>Description:</b> Saddle, Aft Outboard | <b>Part Number:</b> D2573 |
| <b>Inspection Dwg:</b> D2573 Rev. E      | <b>Page 1 of 1</b>        |

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

| Dim           | Min   | Max   | Go/No Go Gauge | Recorded Actual Dimensions |       |       |       | By | Date |
|---------------|-------|-------|----------------|----------------------------|-------|-------|-------|----|------|
|               |       |       |                | 1                          | 2     | 3     | 4     |    |      |
| A             | 0.438 | 0.443 | DT8682         | ✓                          | ✓     | ✓     | ✓     |    |      |
| B             | 1.745 | 1.755 |                | 1.747                      | 1.748 | 1.748 | 1.747 |    |      |
| C             | 3.495 | 3.505 |                | 3.499                      | 3.500 | 3.495 | 3.498 |    |      |
| D             | 1.745 | 1.755 |                | 1.747                      | 1.748 | 1.748 | 1.747 |    |      |
| E             | 7.990 | 8.010 |                | 8.004                      | 8.005 | 8.004 | 8.004 |    |      |
| F             | 0.490 | 0.510 |                | 0.503                      | 0.498 | 0.500 | 0.501 |    |      |
| G             | 0.257 | 0.262 | DT8683         | ✓                          | ✓     | ✓     | ✓     |    |      |
| H             | 0.375 | 0.380 | DT8684         | ✓                          | ✓     | ✓     | ✓     |    |      |
| I             | 0.490 | 0.510 |                | 0.501                      | 0.498 | 0.501 | 0.501 |    |      |
| J             | 1.174 | 1.184 |                | 1.178                      | 1.175 | 1.176 | 1.176 |    |      |
| K             | 0.558 | 0.578 |                | 0.568                      | 0.566 | 0.563 | 0.562 |    |      |
| L             | 1.174 | 1.184 |                | 1.178                      | 1.175 | 1.176 | 1.176 |    |      |
| M             | 1.365 | 1.375 |                | 1.368                      | 1.367 | 1.368 | 1.367 |    |      |
| N             | 2.495 | 2.505 |                | 2.500                      | 2.500 | 2.495 | 2.496 |    |      |
| O             | 4.119 | 4.129 |                | 4.122                      | 4.123 | 4.120 | 4.123 |    |      |
| P             | 0.115 | 0.135 |                | 0.123                      | 0.125 | 0.125 | 0.125 |    |      |
| Q             | 0.115 | 0.135 |                | 0.135                      | 0.135 | 0.135 | 0.135 |    |      |
| R             | 0.240 | 0.260 |                | 0.253                      | 0.254 | 0.254 | 0.254 |    |      |
| S             | 0.115 | 0.135 |                | 0.118                      | 0.120 | 0.120 | 0.122 |    |      |
| T             | 0.178 | 0.198 |                | 0.188                      | 0.188 | 0.188 | 0.188 |    |      |
| U             | 3.210 | 3.250 |                | 3.230                      | 3.230 | 3.230 | 3.230 |    |      |
| V             | 0.230 | 0.250 |                | 0.230                      | 0.230 | 0.240 | 0.240 |    |      |
| W             | 0.115 | 0.135 |                | 0.122                      | 0.123 | 0.123 | 0.118 |    |      |
| X             | 0.308 | 0.313 |                | 0.309                      | 0.310 | 0.308 | 0.310 |    |      |
| Y             | 0.760 | 0.765 |                | 0.760                      | 0.766 | 0.760 | 0.760 |    |      |
| Z             | 0.352 | 0.372 |                | 0.369                      | 0.369 | 0.369 | 0.369 |    |      |
| AA            | 0.470 | 0.530 |                | 0.500                      | 0.500 | 0.500 | 0.500 |    |      |
| AB            | 0.615 | 0.635 |                | 0.632                      | 0.626 | 0.629 | 0.631 |    |      |
| AC            | 0.053 | 0.073 |                | 0.063                      | 0.063 | 0.063 | 0.063 |    |      |
| AD            | 0.240 | 0.260 |                | 0.248                      | 0.243 | 0.249 | 0.244 |    |      |
| AE            | 1.500 | 1.520 |                | 1.512                      | 1.510 | 1.512 | 1.513 |    |      |
| AF            | 0.115 | 0.135 |                | 0.135                      | 0.135 | 0.135 | 0.135 |    |      |
| AG            | 0.240 | 0.280 |                | 0.260                      | 0.260 | 0.260 | 0.260 |    |      |
| AH            | 0.240 | 0.260 |                | 0.248                      | 0.249 | 0.250 | 0.251 |    |      |
| AI            | 2.000 | 2.020 |                | 2.002                      | 2.000 | 2.002 | 2.002 |    |      |
| AJ            | 0.023 | 0.043 |                | 0.033                      | 0.038 | 0.033 | 0.033 |    |      |
| Accept/Reject |       |       |                |                            |       |       |       |    |      |

|                             |
|-----------------------------|
| Measured by: <i>SP 19nd</i> |
| Date: 06/09/17              |

|                       |
|-----------------------|
| Audited by: <i>MS</i> |
| Date: 06/09/22        |

| Rev | Date     | Change                                  | Revised by | Approved |
|-----|----------|---|------------|----------|
| A   |          | New Issue                               | RF         |          |
| B   | 02.09.26 | Re-format; Added Rev. D                 | KJ         |          |
| C   | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ         |          |
| D   | 05.05.05 | Added dimension AI                      | KJ/RF      |          |
| E   | 05.12.05 | Added dimension AJ                      | KJ/JLM     |          |



|  |                           |
|--|---------------------------|
| <b>DART AEROSPACE LTD</b>                | <b>Work Order:</b> 27994  |
| <b>Description:</b> Saddle, Aft Outboard | <b>Part Number:</b> D2573 |
| <b>Inspection Dwg:</b> D2573 Rev. E      | <b>Page 1 of 1</b>        |

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

| Dim           | Min   | Max   | Go/No Go Gauge | Recorded Actual Dimensions |       |       |         | By | Date |
|---------------|-------|-------|----------------|----------------------------|-------|-------|---------|----|------|
|               |       |       |                | 1                          | 2     | 3     | 4<br>12 |    |      |
| A             | 0.438 | 0.443 | DT8682         | —                          | —     | —     | —       |    |      |
| B             | 1.745 | 1.755 |                | 1.749                      | 1.746 | 1.750 | 1.745   |    |      |
| C             | 3.495 | 3.505 |                | 3.501                      | 3.500 | 3.498 | 3.499   |    |      |
| D             | 1.745 | 1.755 |                | 1.745                      | 1.746 | 1.750 | 1.745   |    |      |
| E             | 7.990 | 8.010 |                | 8.006                      | 8.004 | 8.005 | 8.004   |    |      |
| F             | 0.490 | 0.510 |                | 0.499                      | 0.498 | 0.498 | 0.493   |    |      |
| G             | 0.257 | 0.262 | DT8683         | —                          | —     | —     | —       |    |      |
| H             | 0.375 | 0.380 | DT8684         | —                          | —     | —     | —       |    |      |
| I             | 0.490 | 0.510 |                | 0.499                      | 0.499 | 0.499 | 0.501   |    |      |
| J             | 1.174 | 1.184 |                | 1.175                      | 1.175 | 1.175 | 1.175   |    |      |
| K             | 0.558 | 0.578 |                | 0.564                      | 0.563 | 0.565 | 0.564   |    |      |
| L             | 1.174 | 1.184 |                | 1.175                      | 1.175 | 1.175 | 1.175   |    |      |
| M             | 1.365 | 1.375 |                | 1.368                      | 1.369 | 1.367 | 1.367   |    |      |
| N             | 2.495 | 2.505 |                | 2.496                      | 2.495 | 2.497 | 2.496   |    |      |
| O             | 4.119 | 4.129 |                | 4.124                      | 4.122 | 4.121 | 4.119   |    |      |
| P             | 0.115 | 0.135 |                | 0.125                      | 0.123 | 0.124 | 0.123   |    |      |
| Q             | 0.115 | 0.135 |                | 0.135                      | 0.135 | 0.135 | 0.135   |    |      |
| R             | 0.240 | 0.260 |                | 0.252                      | 0.253 | 0.254 | 0.253   |    |      |
| S             | 0.115 | 0.135 |                | 0.118                      | 0.120 | 0.121 | 0.120   |    |      |
| T             | 0.178 | 0.198 |                | 0.188                      | 0.188 | 0.188 | 0.188   |    |      |
| U             | 3.210 | 3.250 |                | 3.230                      | 3.230 | 3.230 | 3.230   |    |      |
| V             | 0.230 | 0.250 |                | 0.241                      | 0.238 | 0.237 | 0.239   |    |      |
| W             | 0.115 | 0.135 |                | 0.122                      | 0.121 | 0.123 | 0.119   |    |      |
| X             | 0.308 | 0.313 |                | 0.316                      | 0.308 | 0.310 | 0.316   |    |      |
| Y             | 0.760 | 0.765 |                | 0.760                      | 0.760 | 0.760 | 0.760   |    |      |
| Z             | 0.352 | 0.372 |                | 0.365                      | 0.364 | 0.368 | 0.364   |    |      |
| AA            | 0.470 | 0.530 |                | 0.500                      | 0.500 | 0.500 | 0.500   |    |      |
| AB            | 0.615 | 0.635 |                | 0.626                      | 0.626 | 0.632 | 0.630   |    |      |
| AC            | 0.053 | 0.073 |                | 0.063                      | 0.063 | 0.063 | 0.063   |    |      |
| AD            | 0.240 | 0.260 |                | 0.244                      | 0.244 | 0.246 | 0.249   |    |      |
| AE            | 1.500 | 1.520 |                | 1.510                      | 1.511 | 1.513 | 1.511   |    |      |
| AF            | 0.115 | 0.135 |                | 0.135                      | 0.135 | 0.135 | 0.135   |    |      |
| AG            | 0.240 | 0.280 |                | 0.260                      | 0.260 | 0.260 | 0.260   |    |      |
| AH            | 0.240 | 0.260 |                | 0.251                      | 0.251 | 0.246 | 0.244   |    |      |
| AI            | 2.000 | 2.020 |                | 2.000                      | 2.001 | 2.003 | 2.001   |    |      |
| AJ            | 0.023 | 0.043 |                | 0.033                      | 0.033 | 0.033 | 0.033   |    |      |
| Accept/Reject |       |       |                |                            |       |       |         |    |      |

|                            |
|----------------------------|
| Measured by: <i>En 19m</i> |
| Date: 06/07/17             |

|                                |
|--------------------------------|
| Audited by: <i>MS 06/09/22</i> |
| Date:                          |

| Rev | Date     | Change                                  | Revised by | Approved |
|-----|----------|---|------------|----------|
| A   |          | New Issue                               | RF         |          |
| B   | 02.09.26 | Re-format; Added Rev. D                 | KJ         |          |
| C   | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ         |          |
| D   | 05.05.05 | Added dimension AI                      | KJ/RF      |          |
| E   | 05.12.05 | Added dimension AJ                      | KJ/JLM     |          |



|  |                           |
|--|---------------------------|
| <b>DART AEROSPACE LTD</b>                | <b>Work Order:</b> 27994  |
| <b>Description:</b> Saddle, Aft Outboard | <b>Part Number:</b> D2573 |
| <b>Inspection Dwg:</b> D2573 Rev. E      | <b>Page 1 of 1</b>        |

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

|               |       |       |                | Recorded Actual Dimensions |       |       |           | By | Date |
|---------------|-------|-------|----------------|----------------------------|-------|-------|-----------|----|------|
| Dim           | Min   | Max   | Go/No Go Gauge | 1                          | 2     | 3     | 4<br>1/16 |    |      |
| A             | 0.438 | 0.443 | DT8682         | ✓                          | ✓     | ✓     | ✓         |    |      |
| B             | 1.745 | 1.755 |                | 1.749                      | 1.750 | 1.750 | 1.750     |    |      |
| C             | 3.495 | 3.505 |                | 3.500                      | 3.500 | 3.500 | 3.500     |    |      |
| D             | 1.745 | 1.755 |                | 1.749                      | 1.750 | 1.750 | 1.750     |    |      |
| E             | 7.990 | 8.010 |                | 8.005                      | 8.006 | 8.005 | 8.005     |    |      |
| F             | 0.490 | 0.510 |                | 0.501                      | 0.505 | 0.501 | 0.502     |    |      |
| G             | 0.257 | 0.262 | DT8683         |                            |       |       |           |    |      |
| H             | 0.375 | 0.380 | DT8684         | ✓                          | ✓     | ✓     | ✓         |    |      |
| I             | 0.490 | 0.510 |                | 0.504                      | 0.502 | 0.502 | 0.502     |    |      |
| J             | 1.174 | 1.184 |                | 1.186                      | 1.179 | 1.179 | 1.179     |    |      |
| K             | 0.558 | 0.578 |                | 0.568                      | 0.568 | 0.567 | 0.568     |    |      |
| L             | 1.174 | 1.184 |                | 1.180                      | 1.179 | 1.179 | 1.179     |    |      |
| M             | 1.365 | 1.375 |                | 1.370                      | 1.376 | 1.370 | 1.370     |    |      |
| N             | 2.495 | 2.505 |                | 2.500                      | 2.506 | 2.500 | 2.500     |    |      |
| O             | 4.119 | 4.129 |                | 4.122                      | 4.121 | 4.121 | 4.122     |    |      |
| P             | 0.115 | 0.135 |                | 0.123                      | 0.123 | 0.122 | 0.122     |    |      |
| Q             | 0.115 | 0.135 |                | 0.135                      | 0.135 | 0.135 | 0.135     |    |      |
| R             | 0.240 | 0.260 |                | 0.254                      | 0.255 | 0.253 | 0.254     |    |      |
| S             | 0.115 | 0.135 |                | 0.120                      | 0.121 | 0.120 | 0.117     |    |      |
| T             | 0.178 | 0.198 |                | 0.188                      | 0.188 | 0.188 | 0.188     |    |      |
| U             | 3.210 | 3.250 |                | 3.230                      | 3.230 | 3.230 | 3.230     |    |      |
| V             | 0.230 | 0.250 |                | 0.243                      | 0.245 | 0.240 | 0.240     |    |      |
| W             | 0.115 | 0.135 |                | 0.121                      | 0.121 | 0.120 | 0.119     |    |      |
| X             | 0.308 | 0.313 |                | 0.316                      | 0.310 | 0.309 | 0.309     |    |      |
| Y             | 0.760 | 0.765 |                | 0.760                      | 0.760 | 0.760 | 0.760     |    |      |
| Z             | 0.352 | 0.372 |                | 0.371                      | 0.367 | 0.366 | 0.369     |    |      |
| AA            | 0.470 | 0.530 |                | 0.500                      | 0.500 | 0.500 | 0.500     |    |      |
| AB            | 0.615 | 0.635 |                | 0.629                      | 0.631 | 0.627 | 0.627     |    |      |
| AC            | 0.053 | 0.073 |                | 0.063                      | 0.063 | 0.063 | 0.063     |    |      |
| AD            | 0.240 | 0.260 |                | 0.253                      | 0.255 | 0.247 | 0.245     |    |      |
| AE            | 1.500 | 1.520 |                | 1.512                      | 1.511 | 1.508 | 1.514     |    |      |
| AF            | 0.115 | 0.135 |                | 0.135                      | 0.135 | 0.135 | 0.135     |    |      |
| AG            | 0.240 | 0.280 |                | 0.260                      | 0.260 | 0.260 | 0.260     |    |      |
| AH            | 0.240 | 0.260 |                | 0.253                      | 0.255 | 0.250 | 0.248     |    |      |
| AI            | 2.000 | 2.020 |                | 2.002                      | 2.001 | 2.003 | 2.005     |    |      |
| AJ            | 0.023 | 0.043 |                | 0.033                      | 0.033 | 0.033 | 0.033     |    |      |
| Accept/Reject |       |       |                |                            |       |       |           |    |      |

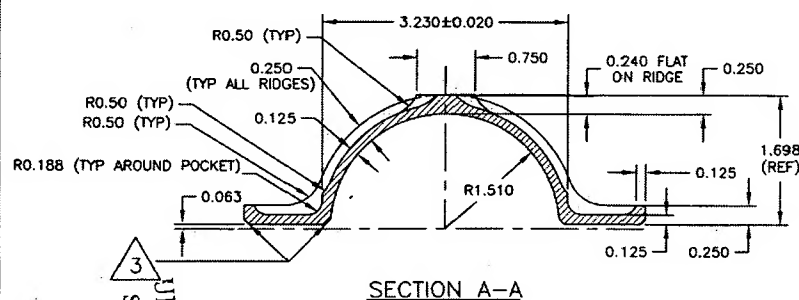
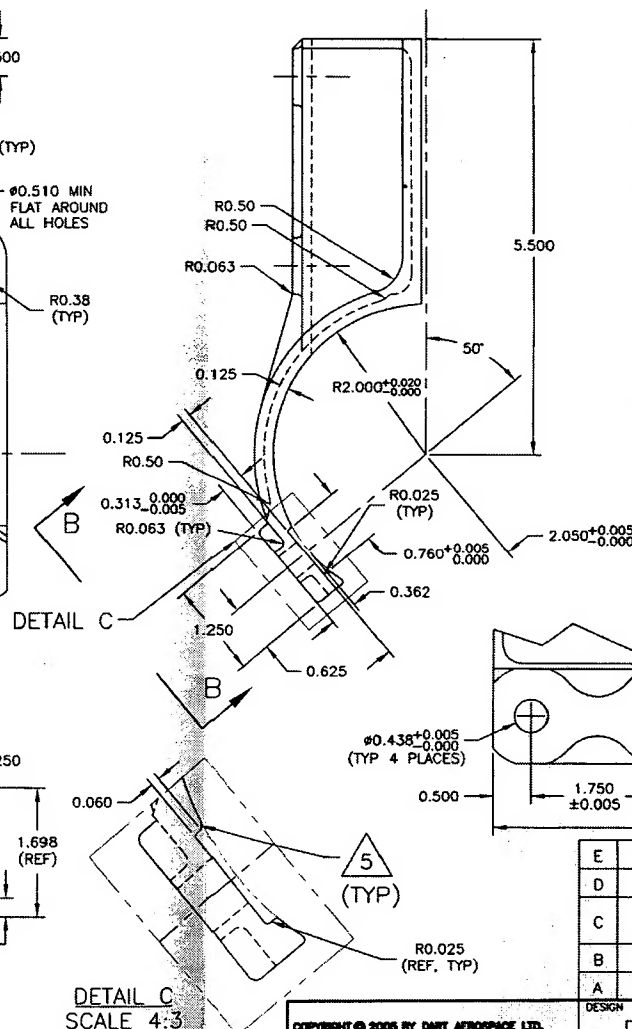
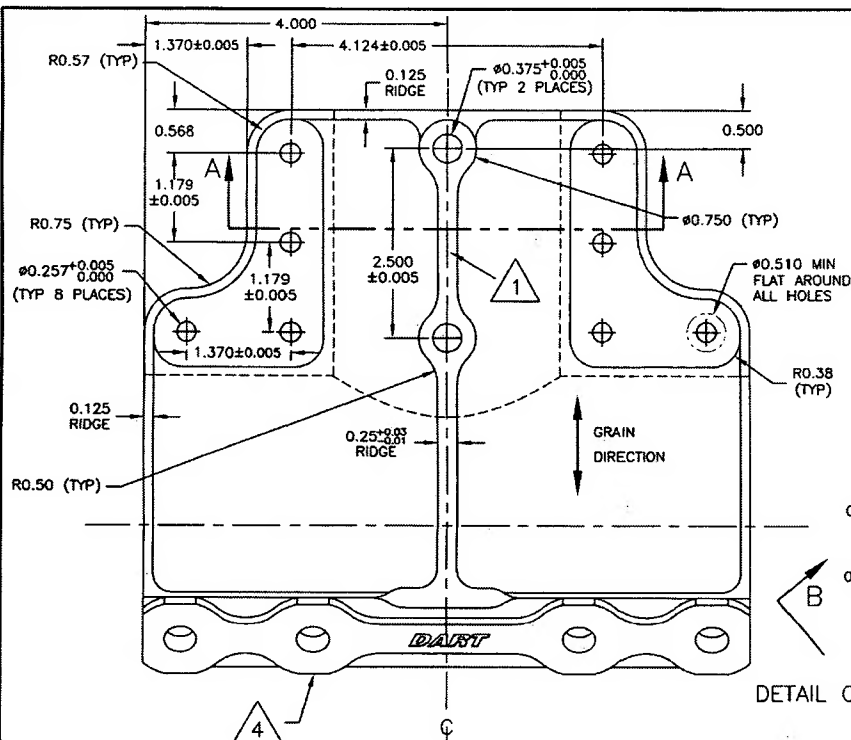
|              |          |
|--------------|----------|
| Measured by: | ML       |
| Date:        | 06/09/17 |

|             |          |
|-------------|----------|
| Audited by: | MS       |
| Date:       | 06/09/22 |

| Rev | Date     | Change                                  | Revised by | Approved |
|-----|----------|---|------------|----------|
| A   |          | New Issue                               | RF         |          |
| B   | 02.09.26 | Re-format; Added Rev. D                 | KJ         |          |
| C   | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ         |          |
| D   | 05.05.05 | Added dimension AI                      | KJ/RF      |          |
| E   | 05.12.05 | Added dimension AJ                      | KJ/JLM     |          |








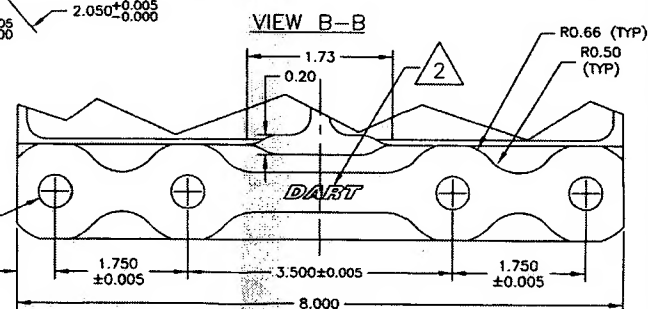
05.12.06






## NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)  
(REF DART SPEC. D6102-001)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED


- |   |  |
|---|--|
|  | ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010 |
|  | ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125       |
|  | CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)      |
|  | CHAMFER 0.063" x 45° ALL AROUND                                  |
|  | CHAMFER 0.033" x 45° (SEE DETAIL C)                              |



|   |   |   |
|---|---|---|
| E   | 05.07.13  | ADD CHAMFER ON RIDGE NOTE 5   |
| D   | 02.09.06  | ADD RIDGES; TIGHTEN TOLERANCES  |
| C   | 99.10.22  | INCP. DEO 9123/9079/9102<br>ADD DIMENSIONS PER TSR A1177                              |
| B   | 96.12.02  | ADD GRAIN DIR., 0.438 WAS 0.425   |
| A   | 96.09.16  | NEW ISSUE   |
| DESIGN  |   | DRAWN BY  |
| DS  | PH  |  |
| CHECKED   | APPROVED  | DRAWING NO.   |
|  |  | D2573   |
| DATE  |   | TITLE   |
| 05.07.13  |   | OUTER AFT SADDLE  |
|   |   | SCALE   |
|   |   | 2:1   |

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| DESIGN  | DS  |
| CHECKED |  |
| DATE    | 05.07.13  |

|          |                    |
|----------|--------------------|
| DRAWN BY | PH                 |
| APPROVED | <i>[Signature]</i> |

|   |  |   |  |
|---|--|---|--|
|  |  | <b>DART AEROSPACE LTD.</b><br>WARRICKSBURY, ONTARIO, CANADA |  |
| DRAWING NO.<br>D2573  |  | REV. 6<br>SHEET 1 OF  |  |
| TITLE<br>OUTER AFT SADDLE   |  | SCALE   |  |

2:3

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